

Date: Monday, 4/23/2007 3:42:09 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CROSSBOLT SPACER
Job Number : 32026	
Estimate Number : 10993	
P.O. Number : <i>N/A</i>	Part Number : D2579
This Issue : 4/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2579 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 31108	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/30/2007 Qty: <i>300</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est E 02.08.17 Now turned on Cobra NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
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Comment: Qty.: 0.3762 f(s)/Unit Total: 112.8645 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) *103588 → 600 pi.*

0.500 Dia x 0.058 Wall

Batch *104007 → 52.8645 pi.* *SG 07.05.09*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

DIP 07/05/11 *SG 07.05.09* *(514)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP *SG 07.05.09*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SG 07/05/11 *(x514)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SG 7/5/11 *SG* *(514)*

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

SG 07/05/11

Job Completion



U 2.05.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

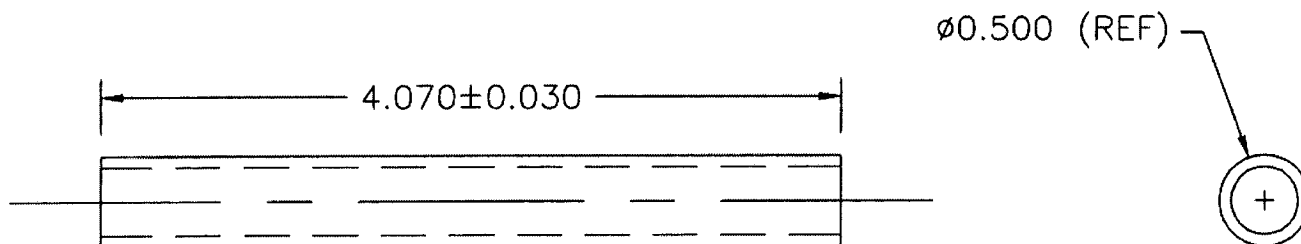
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DA	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DA	APPROVED LE	DRAWING NO. D2579	REV. D SHEET 1 OF 1
DATE 99.05.19		TITLE CROSS BOLT SPACER	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	96.12.05	0.065 WALL WAS 0.035 WALL	
C	97.02.21	0.058 WALL WAS 0.065 WALL	
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)	

RELEASED
99.05.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.500 DIA x 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
NOTED TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32026